

Work Order ID 58192

April 28, 2010 8:32:58 AM



Page 1

Item ID: D4035-041

Accept



Setup Start



Revision ID:

Item Name: Lid Rib Assembly, Fwd (350 Basket)

Stop



Start Date: 4/28/10 Start Qty: 4.00



Cust Item ID:

Required Date: 4/30/10 Req'd Qty: 4.00

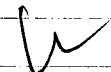


Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Reject
Number**
**Insp.
Stamp**

Draw Nbr	Revision Nbr
D4035	A

100 Weld per dwg A/R S.S. rod Batch: 111679 0.00

Large Fab

Memo

0.00

- 1- Cut D4035-1 as per dwg D4035
- 2- Drill as per dwg D4035 using DT9562
- 3- remove identification marks and deburr
- 4- Weld bushing in rib as per dwg D4035

① PD 10.05.03

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Quality Control

Memo

0.00

④ PD 10.05.03

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

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Start Date: 4/28/10 Start Qty: 4.00



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Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run

Start



Stop

Sequence ID/
Work Center IDOperation
Description

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S. W. 03

0.00

(X4)

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAD

0.00

10-05-07

(4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/05 J

MF 10-5-4

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Picklist Print

April 28, 2010 8:32:57 AM

Page 1

Work Order ID: 58192



Parent Item: D4035-041



Parent Item Name: Lid Rib Assembly, Fwd (350 Basket)

Start Date: 4/28/10

Required Date: 4/30/10

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	26.0000	4.0000			



Spacer Bushing

4/10.05.03

Warehouse

Location

Main Warehouse

WA	26
57186	6
57790	20

4

M304TS0.750W.049



Purchased

No

100 f 874.2312 7.3684



304 SQ Tube .75x.75x.049W

Warehouse

Location

Main Warehouse

MAT	200
113763	0
114323	200

4

Main Warehouse

MAT017	674.2311579
113763	24.25
114270	200
114298	449.981158

4

4/10.05.03

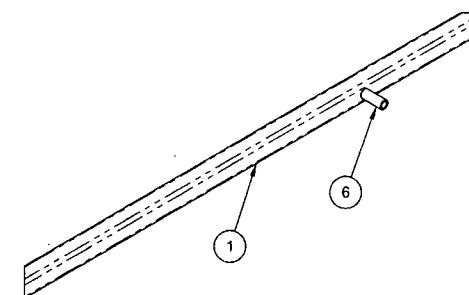
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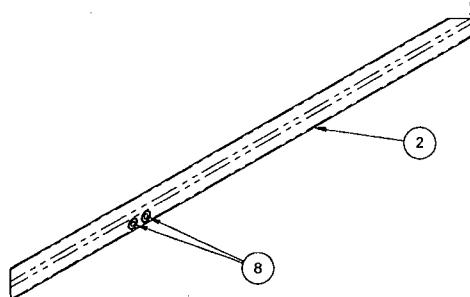
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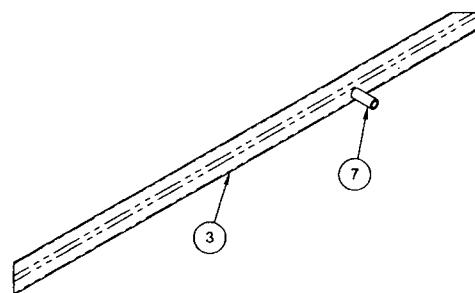
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8				2	D4021-9	BUSHING



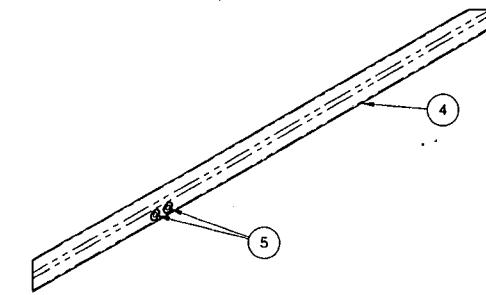
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AM

WLO
S8192

A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		REV. A	SHEET 1 OF 5	
DATE 10.03.04		TITLE		NTS
BASKET LID RIB ASSY				

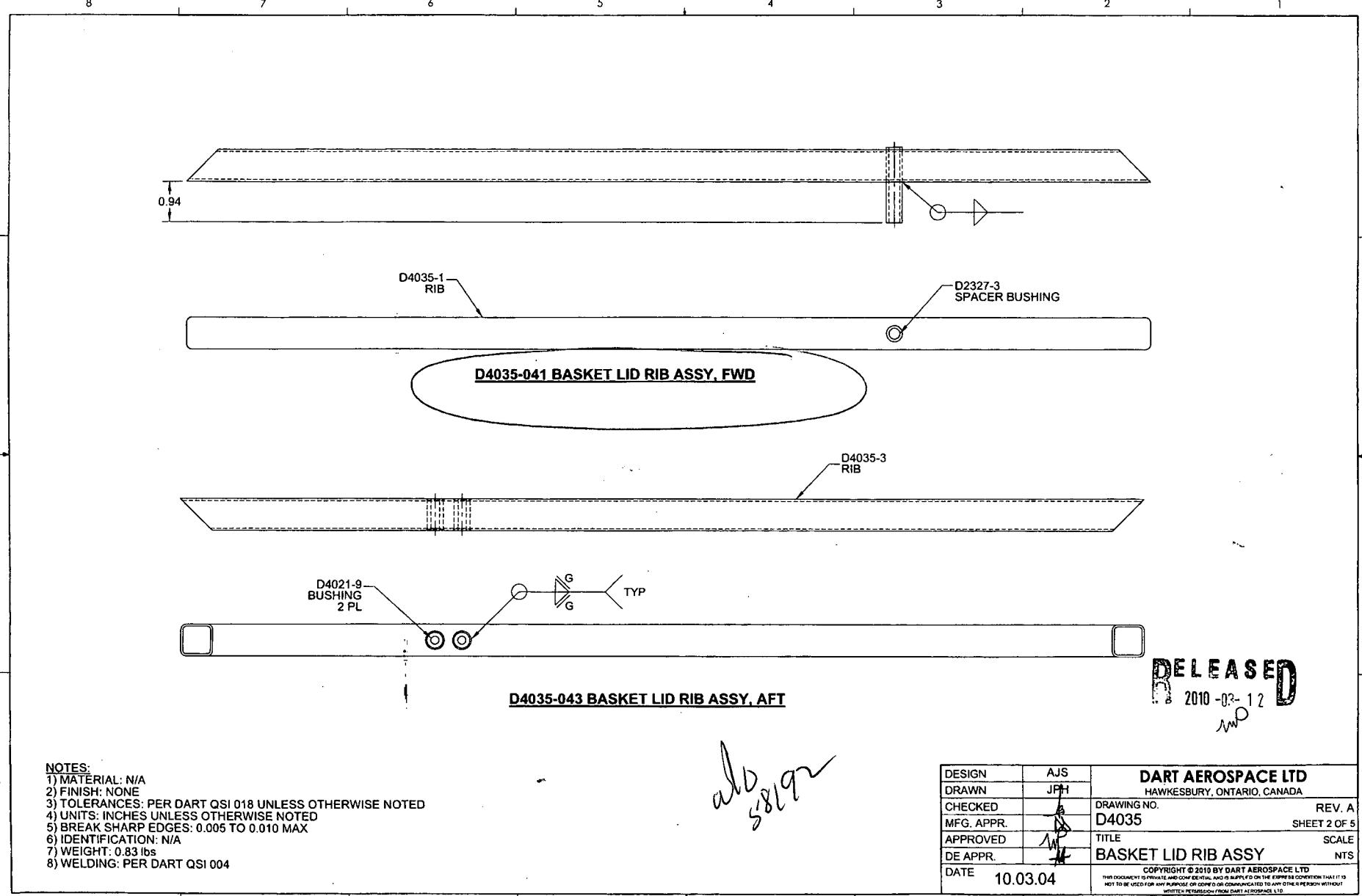
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NOTE: Date & initial all entries



DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>✓</i>	DRAWING NO.
MFG. APPR.	<i>✓</i>	D4035
APPROVED	<i>✓</i>	REV. A
DE APPR.	<i>✓</i>	SHEET 2 OF 5
DATE	10.03.04	TITLE
		BASKET LID RIB ASSY
		SCALE
		NTS

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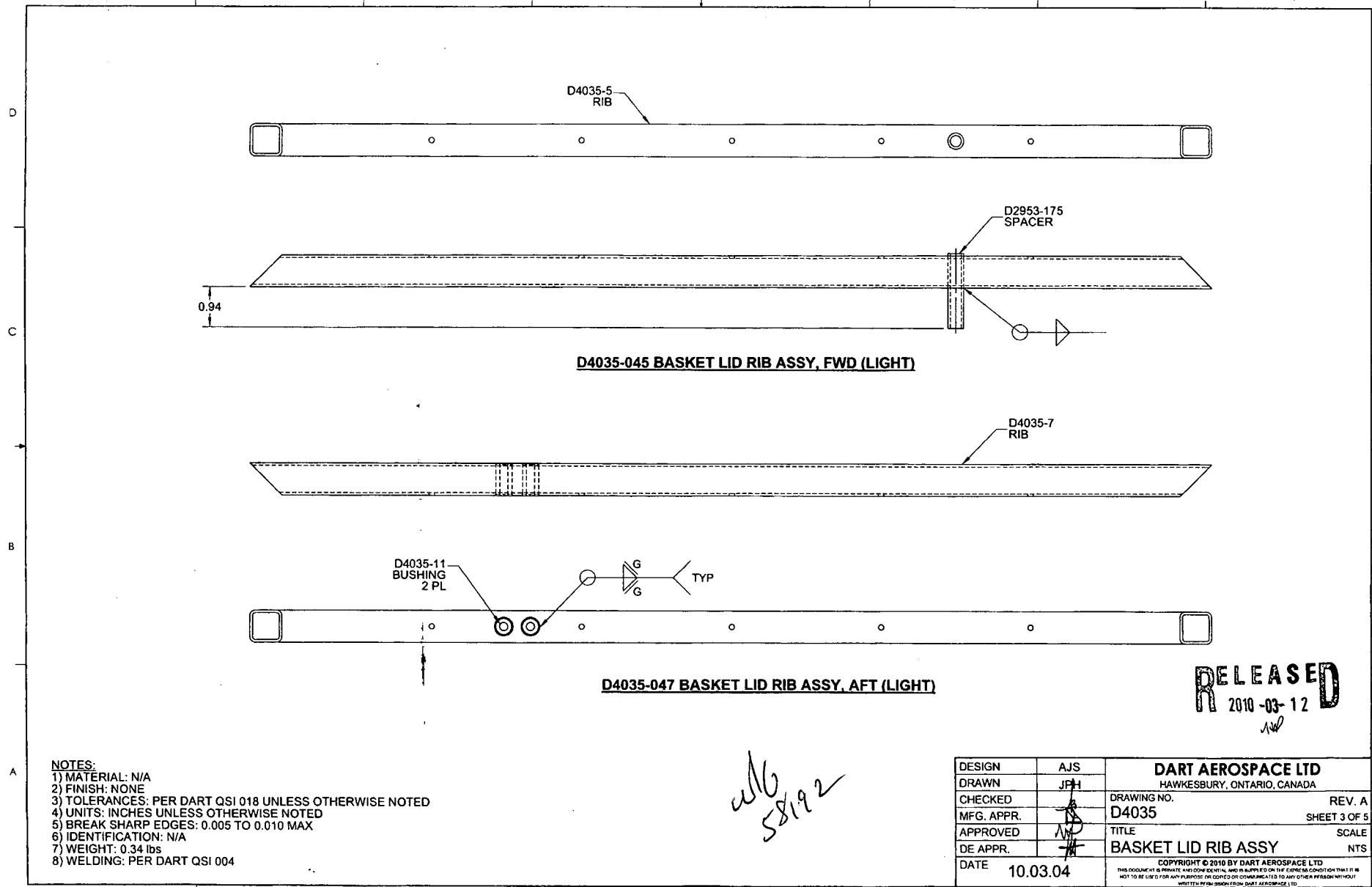
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8 7 6 5 4 3 2 1



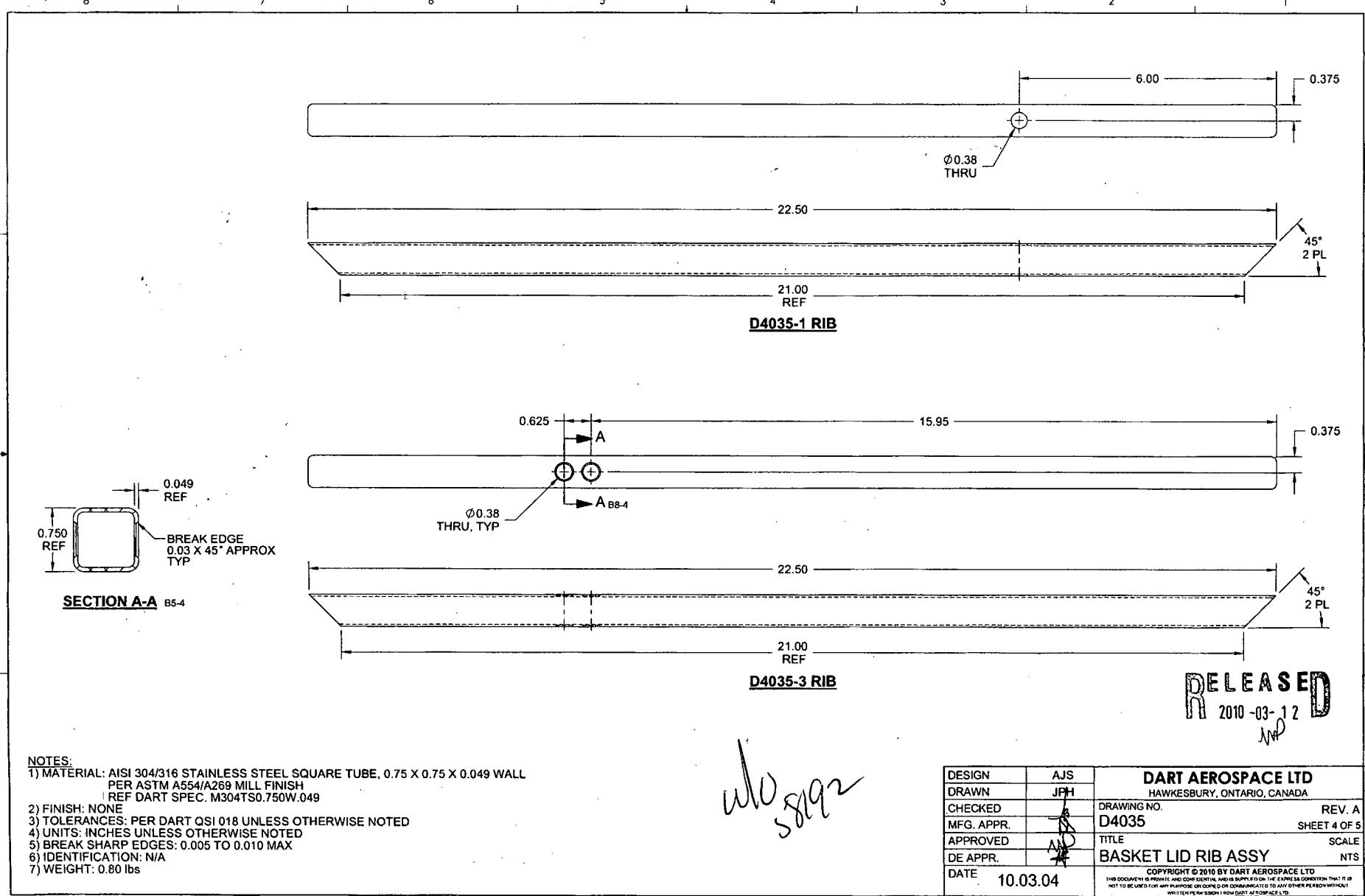
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NOTES

1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.80 lbs

W.W. 58192

DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>b</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>b</i>	D4035	SHEET 4 OF 5	
APPROVED	<i>AB</i>	TITLE	SCALE	
DE APPR.	<i>AB</i>	BASKET LID RIB ASSY	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS		

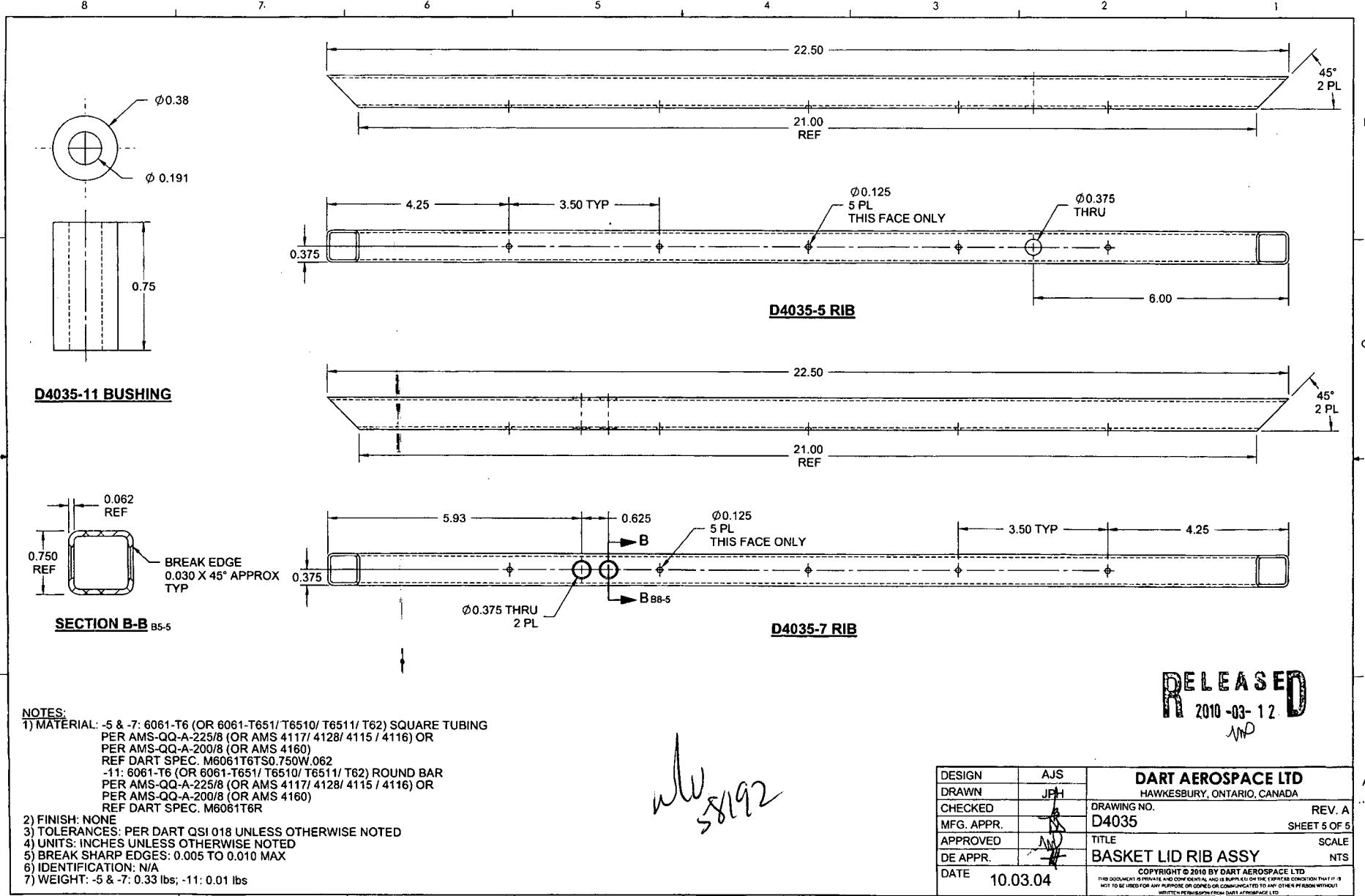
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